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(57) 【要約】

【課題】 被貼着物を押圧する2つの押圧手段をそれぞれ独立に揺動させ、ラベルと被貼着物との間に空気が介在するのを防止するとともに、外部からの圧力で変形し易く、表面に傷が付き易い被貼着物にも適用することができるラベル貼着装置を提供する。

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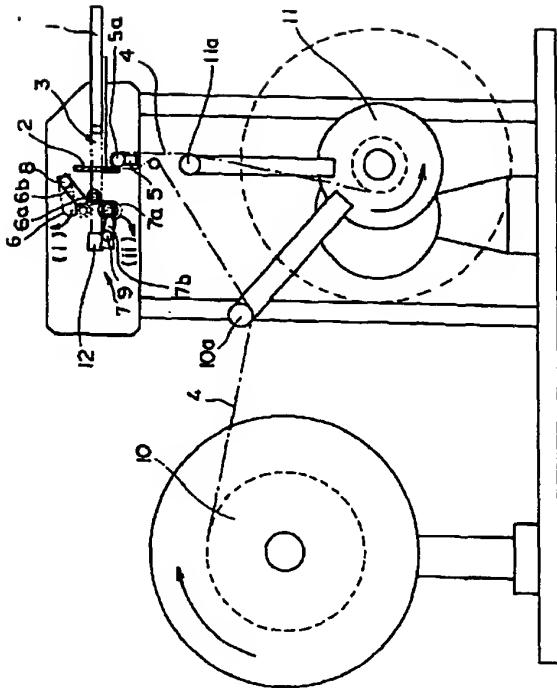
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(57) [Abstract]

[Problem] 2 pressing means which presses object being bonded shaking respectively inindependence, as it prevents fact that air lies between withthe label and object being bonded, it is easy to become deformed with pressurefrom outside, label adhering equipment which can be applied to also object being bonded wherethe damage is easy to be done to surface is offered.

【解決手段】 CDケース1を通過させることができが可能な被貼着物通路3と、台紙4からラベル2を切出すとともに、CDケース1の前面に貼着面を向けて前記被貼着物通路3内に位置させるラベル切出し手段5と、ラベル切出し手段5により切出されたラベル2を貼着しながらCDケース1の前面と表面を押圧する第一の押圧手段及び裏面を押圧する第二の押圧手段とを有し、第1の揺動アーム8及び第2の揺動アーム9がそれぞれ独立に第1の押圧部6及び第2の押圧部7を揺動してCDケース1の形状に追従せるものである。|

[Means of Solution] It is possible to pass CD case 1, object being bonded passageway 3 whose, label 2 is cut from board 4 as, Directing adhering surface to front surface of CD case 1, label which islocated inside aforementioned object being bonded passageway 3 cutting, means 5, label cutting, while adhering doing label 2 which is quarriedout by means 5 it possesses with front surface of CD case 1 and thepressing means of first which presses surface and second pressing means which presses the back surface, it is something where first swinging arm 8 and second swinging arm 9 first push part 6 andthe second push part 7 shake in respective independence and follow to geometryof CD



【特許請求の範囲】 |

【請求項 1】 被貼着物が通過する被貼着物通路と、台紙からラベルを切出すとともに、通過する被貼着物の前端面に貼着面を向けて前記被貼着物通路内に切出したラベルを位置させるラベル切出し手段と、

該ラベル切出し手段により切出されたラベルを、通過する前記被貼着物の前面と一側面とに押圧する第一の押圧手段と、該一側面の裏面に押圧する第二の押圧手段と、を備え、

前記 2 つの押圧手段は、前記ラベルを被貼着物に押圧する押圧部と、この押圧部を揺動させる揺動アームとから構成されるラベル貼着装置。|

【請求項 2】 前記被貼着物通路における前記被貼着物の一側面側、その裏面側の面の少なくとも一方に切欠きを設けたことを特徴とする請求項 1 記載のラベル貼着装置。

[Claim(s)]

[Claim 1] As label is cut from object being bonded passageway and board which object being bonded passes, directing adhering surface to front endface of object being bonded which is passed, it has cut inside aforementioned object being bonded passageway label which is located cutting label, means.

Said label cutting, front surface of aforementioned object being bonded which passes the label which is quarried out by means, and pressing means of the first which in one side surface is pressed and second pressing means which is pressed in the back surface of said one side surface and, having,

As for aforementioned 2 pressing means, push part and this push part which press the aforementioned label in object being bonded label adhering equipment which is formed from the swinging arm which shakes.

[Claim 2] One side surface side of aforementioned object being bonded in aforementioned object being bonded passageway, the label adhering equipment which is stated in Claim 1 which designates that notch is provided in at least one of aspect of back surface side as feature.

## 【0001】

【発明の属する技術分野】本発明は、例えばCDケース等の被貼着物に、その表面から裏面に亘ってラベルを貼着するラベル貼着装置に関する。

## 【0002】

【従来の技術】フロッピィディスクの表面から裏面に亘りラベルを貼着する、いわゆる「くるみ貼り」を行うラベル貼着装置として、台紙から剥離されたラベルをフロッピィディスクの搬送方向先頭端面から表面にかけて押し付ける搖動可能な押さえローラと、裏面に押し付ける固定された支持ローラとを備えたものが知られている。(特開平9-142425号)

## 【0003】

【発明が解決しようとする課題】上記ラベル貼着装置においては、支持ローラが固定されていたので、CDケース等の、縁部に裏裏面からの突起がある被貼着物にラベルを貼着する場合、支持ローラが被貼着物形状に追従せず、ラベルと被貼着物との間に空気が介在してしまい、外観上不具合を生じていた。

【0004】また、装置で、CDケースのように外部からの圧力で変形し易く、表面に傷が付き易いものにラベルを貼着すると、変形や傷の付着により、製品の歩留まりが悪化していた。

## 【0005】

【課題を解決するための手段】本発明は、被貼着物を押圧する2つの押圧手段をそれぞれ独立に搖動させることで、上記問題点を解決する。請求項1に係る発明は、被貼着物が通過する被貼着物通路と、台紙からラベルを切出すとともに、通過する被貼着物の前端面に貼着面を向けて前記被貼着物通路内に切出したラベルを位置させるラベル切出し手段と、該ラベル切出し手段により切出されたラベルを通過する前記被貼着物の前面と一側面とを押圧する第一の押圧手段と、該一側面の裏面を押圧する第二の押圧手段と、を備え、前記2つの押圧手段は、前記ラベルを被貼着物に押圧する押圧部と、この押圧部を搖動させる搖動アームとから構成される。

## [0001]

[Technological Field of Invention] This invention, for example CD case or other object being bonded, from surface extending to back surface, regards label adhering equipment which label adhering is done.

## [0002]

[Prior Art] From transport direction head edge surface of floppy disk applying label which is exfoliated from board as label adhering equipment where from surface of floppy disk it extends to back surface and adhering does label, does so-called "walnut to paste", on surface, support roll which swingable which you push with push roll and you push to back surface and is locked those which have are known. (Japan Unexamined Patent Publication Hei 9-142425 number)

## [0003]

[Problems to be Solved by the Invention] Regarding above-mentioned label adhering equipment, because support roll was locked, when adhering it does label in object being bonded which has protuberance from the front and back surfaces in CD case or other and edge, support roll did not follow to the object being bonded shape, air lay between with label and object being bonded, caused the disadvantage on external appearance.

[0004] In addition, with equipment, like CD case it is easy to be ecomedformed with pressure from outside, when label adhering is done in those where damage is easy to be done to surface, theyield of product was deteriorated by deformation and deposit of the scar.

## [0005]

[Means to Solve the Problems] This invention, 2 pressing means which presses object being bonded by fact that it shakes respectively in independence, solves above-mentioned problem. As for invention which relates to Claim 1, as label is cut from object being bonded passageway and board which object being bonded passes, directing the adhering surface to front endface of object being bonded which is passed, it has cut inside the aforementioned object being bonded passageway label which is located cutting label, the means. said label cutting, front surface of aforementioned object being bonded which passes the label which is quarried out by means and pressing means of the first which presses one side surface and second pressing means which presses back surface of the said one side surface and, it has, aforementioned 2 pressing means, is formed push part and this push part which press aforementioned label in object being bonded from the swinging arm which shakes.

【0006】かかる構成によれば、被貼着物通路内を通過する被貼着物は、ラベルを貼着しつつ、その前面と一側面を一方の押圧手段で、該一側面の裏面を他方の押圧手段でそれぞれの面に独立に追従させて押圧する。請求項2にかかる構成によれば、被貼着物がその一側面及び該一側面の裏面を押圧されてたわむ際、たわみにより変位した部分が切欠きに入り込む。

#### 【0007】

【発明の効果】以上のように構成した、請求項1に係るラベル貼着装置によれば、被貼着物を押圧する2つの押圧手段をそれぞれ独立に揺動させてるので、押圧手段が被貼着物の一側面及び該一側面の裏面にそれぞれ追従し、ラベルと被貼着物との間に空気の介在を防止でき、見栄えの良い外観が得られる。

【0008】請求項2に係るラベル貼着装置によれば、一側面及び該一側面の裏面を押圧されてたわんだ被貼着物と被貼着物通路との干渉が防止でき、被貼着物への傷付きを防止し、製品の歩留まりが向上できる。

#### 【0009】

【発明の実施の形態】以下、本発明の実施の形態を添付図面に基づいて詳細に説明する。本実施形態に係るラベル貼着装置により、図2に示す、表面（一側面）から裏面（該一側面の裏面）に亘ってラベル2を貼着したCDケース1（被貼着物）が得られる。尚、CDケース1の表面及び裏面の縁には突起1aが突出している。

【0010】ラベル貼着装置は、主な構成要素として図1に示すように、被貼着物通路3と、ラベル切出し手段5と、2つの押圧手段6、7、とを備える。被貼着物通路3は、CDケース1を通過させる通路で、図3に示すように、上面側及び下面側に上面切欠き3a及び下面切欠き3bを設けている。これにより、CDケース1は、その側面側縁部のみが支持されながら被貼着物通路3を通過し、2つの押圧手段6、7、によってその表面が押圧される。

【0011】ラベル切出し手段5は、ローラ5aで台紙4を180°反転させて、台紙4上に所定の間隔で接着されているラベル2を切出し、通過するCDケース1の前面（図1中

[0006] According to this constitution, object being bonded which passes inside the object being bonded passage, while adhering doing label, front surface and one side surface with the pressing means of one side, with pressing means of other following to independence on respective aspect, presses back surface of said one side surface. According to constitution which depends on Claim 2, object being bonded being pressed one side surface and back surface of said one side surface, occasion where it bends, portion which displacement is done enters into notch due to deflection.

#### [0007]

【Effects of the Invention】 Like above it constituted, according to label adhering equipment which relates to the Claim 1, because it shakes respectively in independence, pressing means be able to follow to one side surface of object being bonded and back surface of said one side surface respectively, be able to prevent inclusion of air with the label and object being bonded, external appearance where outward appearance is good is acquired the 2 pressing means which presses object being bonded.

[0008] According to label adhering equipment which relates to Claim 2, being pressed the back surface of one side surface and said one side surface, be able to prevent interference of object being bonded and object being bonded passageway which bend, to prevent scratching to the object being bonded, it can improve yield of product.

#### [0009]

【Embodiment of Invention】 Below, embodiment of this invention is explained in detail on basis of the attached figure. It shows in Figure 2 with label adhering equipment which relates to this embodiment, from the surface (one side surface) extending to back surface (back surface of said one side surface), adhering is done CD case 1 (object being bonded) which is acquired label 2. Furthermore, protuberance 1a overhang has done to surface of the CD case 1 and edge of back surface.

[0010] Label adhering equipment has, as shown in Figure 1 as main constituent, object being bonded passageway 3 and the label cutting means 5 and 2 pressing means 6, 7, with object being bonded passageway 3 as with passageway which passes CD case 1, shown in the Figure 3, has provided upper surface notch 3a and bottom surface notch 3b in top side and the under side. Because of this, CD case 1, while only lateral surface side edge being supported, passes object being bonded passageway 3, surface is pressed 2 pressing means 6, 7, by.

[0011] Label cutting board 4 180° reversing with roll 5a, cutting label 2 which on board 4 has glued with specified interval, directing adhering surface to front surface (left side in Figure

2を位置させる。切出される前のラベル2は、台紙4とともにロール10から巻き出されガイドローラ10aに導かれラベル切出し手段5に達し、ラベル2が切出された後の台紙4は、ガイドローラ11aに導かれロール11に巻き取られる。

【0012】2つの押圧手段は、ラベル切出し手段5により切出されたラベル2をくるみ貼りしながら、通過されるCDケース1の前面（図1中左端の側面）と一側面である表面（同図中上面）とを一連の動作で押圧する第一の押圧手段6（第1の押圧部6a及び第1の揺動アーム6b）と、前記一側面の裏面（同図中下面）を押圧する第二の押圧手段7（第2の押圧部7a及び第2の揺動アーム7b）とを有する。

【0013】第1の押圧部6a及び第2の押圧部7aは、いずれも円筒状に形成されたローラで、軸を中心に回転自在である。第1の揺動アーム7b及び第2の揺動アーム8bは、それぞれ第1の押圧部6a及び第2の押圧部7aを支持しつつこれらを揺動させる。CDケース1が被貼着物通路3内を通過して各押圧部に当接すると、第1の揺動アーム6bは揺動軸8を中心に（i）方向へ、又、第2の揺動アーム7bは揺動軸9を中心に（ii）方向へそれぞれ独立に揺動する。

【0014】第1の揺動アーム8は、CDケース1の前面から一側面にかけて連続して押圧するようCDケース1が通過する側と反対側に屈曲している。第1の揺動アーム8は（i）と逆方向へ、又、第2の揺動アーム9は（ii）と逆方向へ不図示のばねで付勢され、CDケース1に対し常に押圧力を付与している。動作を、図4（A）～（H）に基づいて説明する。

【0015】ラベル2を貼着しようとするCDケース1を被貼着物通路3内を通過させ（図4（A））、台紙4から切出されたラベル2の貼着面にCDケース1の前面を接触させる。この時、CDケース1を通過させる力で、第1の押圧部6がラベル2をCDケース1の前面に押圧する（同図（B））。更に、CDケース1が被貼着物通路3内を図中左側へ通過されると、第1の押圧部6aが押され、これを支持する第1の揺動アーム6bが揺動軸8aを中心に矢印（i）方向へ揺動するとともに、第2の押圧部7aが押されて、これを支持する第2の揺動アームも揺動軸9aを中心に矢印（ii）方向へ揺動する（同図（C））。そして、第1の押圧部6a及び第2の押圧部7aで、通過するCDケース1の突起1aにラベル2を押圧する。|

located inside object being bonded passageway 3. Before being quarried out, label 2 with board 4 windout is done from roll 10 and is led by guide roll 10a and label cuts and reaches to means 5, after label 2 is quarried out, board 4 is led by the guide roll 11a and is retracted in roll 11.

[0012] label cutting, while walnut doing to paste label 2 which is squaried out by means 5, front surface of CD case 1 which is passed (side face of left end in Figure 1) with surface which is a one side surface (top surface in same Figure) with pressing means 6 of first which is pressed with consecutive operation (first push part 6a and first swinging arm 6b) with, second pressing means 7 which presses the back surface (bottom surface in same Figure) of aforementioned one side surface (second push part 7a and second swinging arm 7b) with it possesses the 2 pressing means.

[0013] First push part 6a and second push part 7a, with roll which in each case was formed to cylinder, axis are freely rotating in center. As for first swinging arm 7b and second swinging arm 8b, while supporting respective first push part 6a and second push part 7a, these it shakes. CD case 1 passing inside object being bonded passageway 3, when it contacts each push part, as for first swinging arm 6b shaking axial 8 in center to (i) direction, as for also, second swinging arm 7b shaking axial 9 in center (ii) direction, it shakes in independence.

[0014] First swinging arm 8, from front surface of CD case 1 applying on one side surface, continuing, in order to press, bending has done side which the CD case 1 passes and in opposing side. As for first swinging arm 8 (i) with to reverse direction, as for also, second swinging arm 9 (ii) with to thereverse direction energization it is done with spring of not shown in the diagram, always it grants pushing pressure vis-a-vis CD case 1. On basis of Figure 4 (A) to (H) you explain operation.

[0015] Front surface of CD case 1 it contacts adhering surface of label 2 which passing inside object being bonded passageway 3, (Figure 4 (A)), is quarried out CD case 1 which the adhering it tries to do label 2 from board 4. This time, by power which passes CD case 1, first push part 6 presses the label 2 in front surface of CD case 1, (same Figure (B)). Furthermore, when CD case 1 inside object being bonded passageway 3 is passed to in the diagram left side, the first push part 6a is pushed, first swinging arm 6b which supports this as in center it shakes to arrow (i) direction, second push part 7a being pushed shaking axial 8a, also second swinging arm which supports this shaking shaft 9a in the center shakes to arrow (ii) direction (same Figure (C)). And, label 2 is pressed in protuberance 1a of CD case 1 which with the first push part 6a and second push part 7a, is passed.

【0016】突起1aに対するラベル2の押圧が終了すると、つづいて押圧部6a、7aがCDケース1表面に追従して押圧するため、第1の揺動アーム6bは矢印(i)'方向へ揺動し、同様に第2の揺動アーム7bは矢印(ii)'方向へ揺動する(同図(D))。第1の揺動アーム6b及び第2の揺動アーム7bがそれぞれ独立に揺動するため、突起1aから表面又は裏面を連続的に押圧する際、それぞれの形状に追従してラベルを貼着できる。

【0017】ラベル2の押圧が終了すると、ラベル2の厚み分だけ第1の揺動アーム6b、及び第2の揺動アーム7bが矢印(i)'又は(ii)'方向へ揺動する(同図(E))。この時、CDケース1の前面がストッパー12に当接して更に押圧される。尚、ここでも第1の揺動アーム6b及び第2の揺動アーム7bは、第1の押圧部6又は第2の押圧部7がラベル2貼着後のCDケース1の表面形状に追従するよう揺動している。

【0018】以上で、CDケース1の通過動作は終了し、続いてCDケース1を後退させる(同図(F)及び(G))。後退時も、第1の押圧部6及び第2の押圧部7は、CDケース1の表面及び裏面を押圧し、貼着を確実にする。最後に、ラベル2が貼着されたCDケース1を被貼着物通路3から排出し、一連のラベル貼着が終了する(同図(H))とともに、次に貼着されるラベル2がロール10及びロール11の回転により送り出される。

【0019】より好適なラベルの貼着には、ラベル切出し手段5によるラベル2の切出し速度を16~100m/minとし、通過するCDケース1の速度を20~66m/minとするのが好ましい。ラベルの切出し速度とロール11による巻取り径との関係を図5に示す。斜線を施した範囲が切出し速度推奨範囲である。|

【0020】第1の押圧部6a又は第2の押圧部7aがCDケース1の表面及び裏面を押圧する際、どちらかの押圧力が大きいと、押圧力が小さい方へCDケース1がたわむが、本実施形態では、図3に示すように被貼着物通路3に切欠き3a、3bを設けたため、たわんだ部分の被貼着物通路3への干渉を防止できる。この切欠き3a、3bは、被貼着物通路3の上面及び下面を、通過するCDケース1の幅より小さく切欠き、かつ、第1の押圧部6a及び第2の押圧部7aの幅より大きく切欠いたもので、これにより、通過するCDケース1は、側面側縁部のみが支持されつつ被貼着物通路3を通過するとともに、2つの押圧手段6、7、は、切欠き3a、3bを通ってCDケース1の表面を押圧する。

[0016] When pressure of label 2 for protuberance 1a ends, continuing, push part 6a and 7a following to CD case 1 surface, in order to press, first swinging arm 6b shakes to arrow (i)' direction, second swinging arm 7b shakes in same way to arrow (ii)' direction ( same Figure (D)). Because first swinging arm 6b and second swinging arm 7b shake respectively in independence, the occasion where front surface or back surface is pressed in continuous, following to respective geometry, adhering is possible label.

[0017] When pressure of label 2 ends, just thick part of label 2 the first swinging arm 6b, and second swinging arm 7b shake to arrow (i)' or (ii)' direction( same Figure (E)). This time, front surface of CD case 1 contacting stopper 12, furthermore it is pressed. Furthermore first swinging arm 6b and second swinging arm 7b, in order for first push part 6 or second push part 7 to follow to surface profile of CD case 1 after label 2 adhering, shake even here.

[0018] At above, passing operation of CD case 1 ends, continuously CD case 1 backs up ( same Figure (F) and (G)). When backing up, first push part 6 and second push part 7 press surface and back surface of CD case 1, make adhering secure. Lastly, label 2 discharges CD case 1 which adhering is done from the object being bonded passageway 3, with ( same Figure (H)) where consecutive label adhering ends, next the label 2 which adhering is done is sent out by revolution of the roll 10 and roll 11.

[0019] From, label cutting, label 2 due to means 5 cutting, it designates velocity as 16 to 100 m/min in adhering of preferred label, it is desirable to designate velocity of CD case 1 which is passed as the 20 to 66 m/min . label cutting, between velocity and winding diameter due to roll 11 it shows relationship in Figure 5. Range which administers slanted line cutting, it is a velocity recommendation range.

[0020] Occasion where first push part 6a or second push part 7a presses surface and the back surface of CD case 1, when either pushing pressure is large, CD case 1 bends to the one where pushing pressure is small, but with this embodiment, as shown in the Figure 3, because notch 3a,3b is provided in object being bonded conduit 3, interference to the object being bonded conduit 3 of portion which bends can be prevented. As for CD case 1 to which this notch 3a,3b is smaller than top surface of the object being bonded conduit 3 and width of CD case 1 which passes bottom surface, notch, at the same time, to be larger than width of first push part 6a and second push part 7a being something which notch is, because of this, passes, while only lateral surface side edge being supported, as object being bonded conduit 3 is passed, as for the 2 pressing means 6,7,, passing by notch 3a,3b, you press surface of CD case 1.

【0021】以上、本発明に係る実施形態について説明したが、本発明はこれに限定されない。被貼着物の材質は、ポリカーボネート、ポリエチレン、ポリ塩化ビニル等や、ポリスチレン、ケブラといったエンプラ材料一般に適用でき、又、紙、木にも適用できる。又、CDケースに限らず表裏面を有する箱状のもの、板状のもの、その他種々の物品の形態に適用できる。

[0021] You explained above, concerning embodiment which relates to this invention, but this invention is not limited in this. polycarbonate, polyethylene and polyvinyl chloride etc and, engineering plastic charge such as the polystyrene and Kevlar be able to apply material of object being bonded, generally, it can apply to also also, paper and wood. Those of box which possesses front and back surfaces not just also, CD case. Those of platelet. In addition it can apply to shape of various goods.

【図面の簡単な説明】

【図1】本発明によるラベル貼着装置を示す側面断面図

【図2】本発明の実施形態に適用されるCDケースの斜視図

【図3】本発明によるラベル貼着装置の被貼着物通路を示す模式図

【図4】本発明によるラベル貼着装置の作用を示す側面模式図

【図5】本発明によるラベル貼着装置のラベルの切出し速度とロール11による巻取り径との関係を示すグラフ

【符号の説明】

1…CDケース（被貼着物）

2…ラベル

3…被貼着物通路

5…ラベル切出し手段

6…第1の押圧手段

7…第2の押圧手段

【Brief Explanation of the Drawing(s)】

【Figure 1】 Label adhering equipment due to this invention is shown side face sectional view

【Figure 2】 Is applied to embodiment of this invention oblique view of CD case which

【Figure 3】 Object being bonded passageway of label adhering equipment due to this invention is shown schematic diagram

【Figure 4】 Action of label adhering equipment with this invention is shown side face schematic diagram

【Figure 5】 Label of label adhering equipment due to this invention cutting, between rate and the winding diameter due to roll 11 it shows relationship graph

【Explanation of Reference Signs in Drawings】

1… CD case (object being bonded)

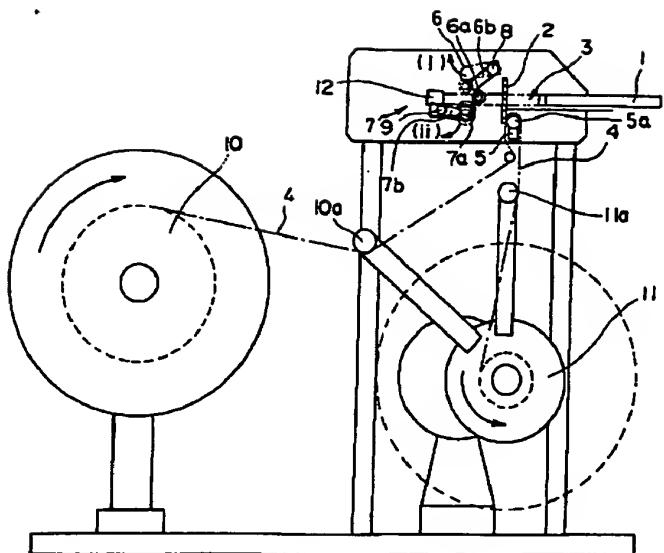
2… label

3… object being bonded passageway

5… label cutting, means

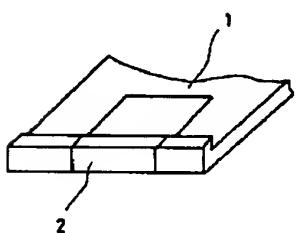
6… first pressing means

7… second pressing means



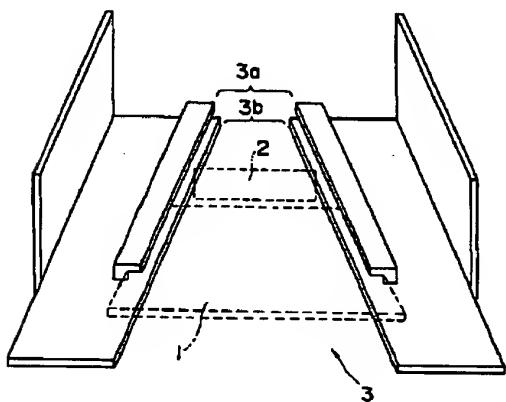
【図2】

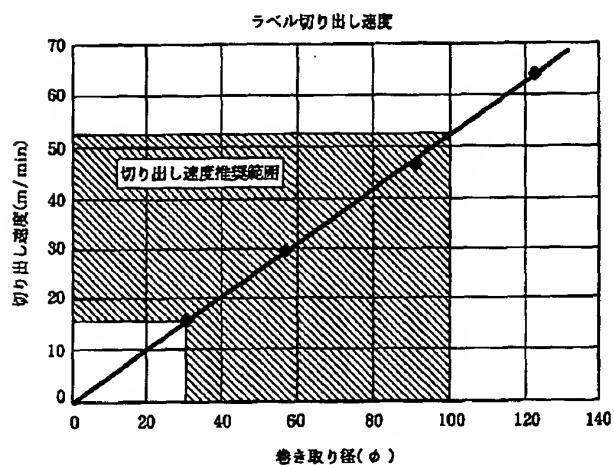
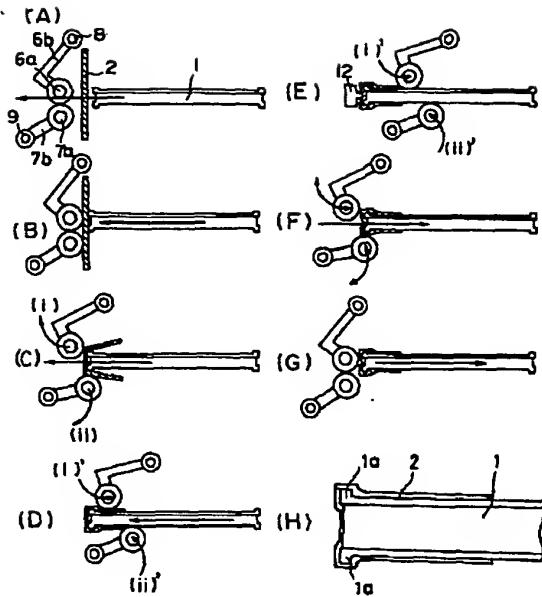
[Figure 2]



【図3】

[Figure 3]





【図 5】

[Figure 5]